



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4037-1
Job Sheet 168690



Part No: D4037-1

Job Qty: 2 ea

Part Name: Aft Crossbeam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/14/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV:D AS PER
ECN 11-554 11-05-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/13/17	0.00	0.00	Start Up Waterjet		17/12/04
100	Waterjet	2 pcs		12/13/17	0.00	1.79	Waterjet1		17/12/04
110	CNC Vertical Machining	2 pcs		12/13/17	0.00	7.41	HAAS 1		unful
120	QC	2 pcs		12/13/17	0.00	0.00	QC2		unful
130	QC	2 pcs		12/13/17	0.00	0.00	QC8		17-12-21
140	HandFinish	2 pcs		12/13/17	0.00	0.38	HandFinish1		2017-12-21/28
150	Powdercoat	2 pcs		12/14/17	0.00	0.40	Powdercoat1		BR 17-12-21
160	QC	2 pcs		12/14/17	0.00	0.00	QC3		17/12/21
170	Packaging	2 pcs		12/14/17	0.00	0.00	Packaging3	ST4H	DEC 22 2017
180	QC21-SA	2 Ea		12/14/17	0.00	0.00	QC21		DEC 22 2017

Part Op 100 - Cut blank as per file D4037-1_BLANK
Descriptions: 110 - MACHINE AS PER FOLI FA877 AND DWG

M 138467. START: 3:20 O/T: 3:00 FINISH: 3:50.

DEC 22 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X16.000	8	26	0	0

Part Specifications

Specifications could not be found.

DA AEROSPACE LTD		Work Order:	168690
Description: Aft Crossbeam		Part Number:	D4037-1
Inspection Dwg: D4037 Rev: E		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.530	+/-0.010	.523	✓		Pin gage	
0.25	+/-0.030	.260	✓		high gage	
2.00	+/-0.030	2.003	✓		Disc	
2.75	+/-0.030	2.750	✓		Vernier	
1.00	+/-0.030	1.024	✓		micrometer	
R0.032	+/-0.010	R.032	✓		Gaborit	
42.87	+/-0.030	42.875	✓		tape	
1.38	+/-0.030	1.376	✓		Vernier	
1.750	+/-0.010	1.749	✓		Vernier	
2.125	+/-0.010	2.124	✓		Vernier	
2.250	+/-0.010	2.249	✓		Vernier	
0.875	+/-0.010	.877	✓		Vernier	
0.875	+/-0.010	.875	✓		high gage	
6.000	+/-0.010	6.000	✓		Vernier	
1.125	+/-0.010	1.125	✓		Vernier	
0.86	+/-0.030	.856	✓		Vernier	
1.38	+/-0.030	1.375	✓		Vernier	
8.04	+/-0.030	8.045	✓		Vernier	
5.29	+/-0.030	5.292	✓		high gage	
Ø0.316	+0.006/-0.001	.3150	✓		Pin gage	
Ø0.391	+0.006/-0.001	.3900	✓		Pin gage	
0.38	+/-0.030	.377	✓		micrometer	
7.75	+/-0.030	7.753	✓		Vernier	
R0.63	+/-0.030	R.063	✓		Gaborit	
R1.00	+/-0.030	R.100	✓		Gaborit	

Measured by:	<i>M. M. M.</i>	Checked by:	<i>B.</i>	QC Inspector:	
Date:	2017/12/20	Date:	17-12-21	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.06.21	Dwg Rev updated	KJ	
C	17.07.13	Dimensions updated per Dwg Rev E	KJ	<i>[Signature]</i>

1.025